

Work Order ID 55733

January 29, 2010 8:25:23 AM



Page 1

Item ID: D3264-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 1/28/10 Start Qty: 12.00



Cust Item ID:

Required Date: 2/08/10 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *R*

Date: *10-1-29*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D3264	Rev A2

100

0.00



Bandsaw

Memo

CUT BLANK 5.700" LONG

0.00

and 10/01/31

12

110

0.00



HAAS 1

Memo

MACHINE AS PER FOLIO FA447

FOLIO REV: *1*

DWG REV: *1*

DEBURR AS PER DWG

0.00

10.2.3

12

HAAS CNC vertical machine #1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3264-1 PAR #: _____ Fault Category: Prod Eng - cancel NCR: Yes No DQA: ✓ Date: 10-02-11
 Resolution: SCVAP Disposition: Scrap QA: N/C Closed: ✓ Date: 10/02/11

NCR: <u>55733</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10.2.3</u>	<u>140</u>	<u>WRONG RAD CUTTER WAS USED</u> <u>TIP DIAMETER WAS NOT IDENTIFIED</u> <u>ON FOLIO.</u> <u>RL. Folio wasn't</u> <u>clean.</u>	<u>10.02.03</u> <u>QS1042</u>	<u>• SCRAP + REPLACE (QTY. 1)</u> <u>• CORRECT FOLIO</u> <u>6061-T6 BAR 1.25 x 4.50</u> <u>B M112628</u>	<u>10.2.3</u>	<u>S</u> <u>10/02/03</u>	<u>10.02.03</u> <u>QS1042</u>	<u>S</u> <u>10/02/03</u>

NOTE: Date & initial all entries

Work Order ID 55733

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Page 2

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Item Name: Bracket

Start Date: 1/28/10 Start Qty: 12.00

Cust Item ID:

Required Date: 2/08/10 Req'd Qty: 12.00

Customer:

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

10.2.3

(12)

1

Quality Control

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

8.8 10/02/03

(12)

1

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

=> 10/02/04

(12)

8

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55733

January 29, 2010 8:25:23 AM



Page 3

Item ID: D3264-1

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Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 1/28/10 Start Qty: 12.00



Cust Item ID:

Required Date: 2/08/10 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00

M113170
Memo

START: 11:45am
TEMP: 370°F

0.00

FIN: 12:15pm

=) M 10/02/08

(12)

φ

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

OK 10-02-8

(12) φ

170



Packaging

Packaging

Identify as per dwg & Stock Location: 149 0.00

Memo

0.00

10/2/08 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55733

January 29, 2010 8:25:23 AM

Page 4

Item ID: D3264-1

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Revision ID:

Stop

Item Name: Bracket

Start Date: 1/28/10 Start Qty: 12.00

Cust Item ID:

Required Date: 2/08/10 Req'd Qty: 12.00

Customer:

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/11

mf

10-2-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 29, 2010 8:25:27 AM

Page 1

Work Order ID: 55733



Parent Item: D3264-1



Parent Item Name: Bracket

Start Date: 1/28/10

Required Date: 2/08/10

Comments: IPP AU04.09.02 New issuef KJ/JLM

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B1.250X04.50 0		Purchased	No				f	45.8096	6.0000			



6061-T6 Bar 1.25 X 4.50

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	45.8096	
105531	0.19	
108855	0.27	
109401	0.82	
111486	3.5296	
→ 112628	41	

6.50 on 10/01/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	35733
Description: Bracket		Part Number:	D3264-1
Inspection Dwg: D3264	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.687	+/-0.010	.683	/			
0.063	+/-0.010	.064	/			
0.125	+/-0.010	.125	/			
0.875	+0.010/-0.020	.878	/			
0.062	+/-0.010	.062	/			
R0.03	+/-0.030	R.01	/			
R0.13	+/-0.030	R.13	/			
1.00	+/-0.030	1.003	/			
0.125	+/-0.010	.125	/			
0.600	+/-0.010	.600	/			
4.000	+/-0.005	4.000	/			
0.750	+/-0.010	.750	/			
Ø0.194	+0.005/-0.000	.194	/			
5.50	+/-0.030	5.502	/			
0.125	+/-0.010	.126	/			
0.063	+/-0.010	.062	/			
R0.25	+/-0.030	R.25	/			
4.27	+/-0.030	4.27	/			
R0.30	+/-0.030	R.30	/			

Measured by:	<i>[Signature]</i>
Date:	10.2.3

Audited by:	<i>[Signature]</i>
Date:	10/02/03

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	
B	05.04.26	Ø0.194 was Ø0.208; dimensions removed	KJ/JLM	
C	07.10.10	Tolerance for 0.875 revised	KJ/EC/DD	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY

SUBJECT TO

DART

WITHOUT
WORK ORDER

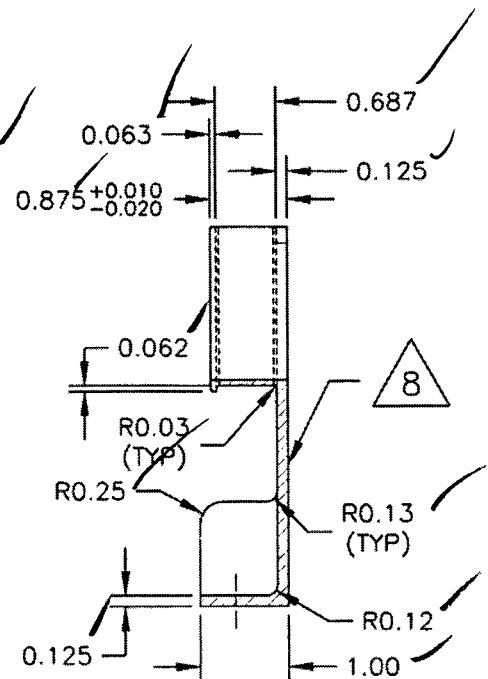
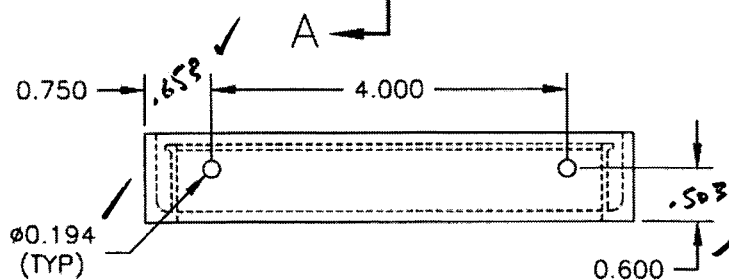
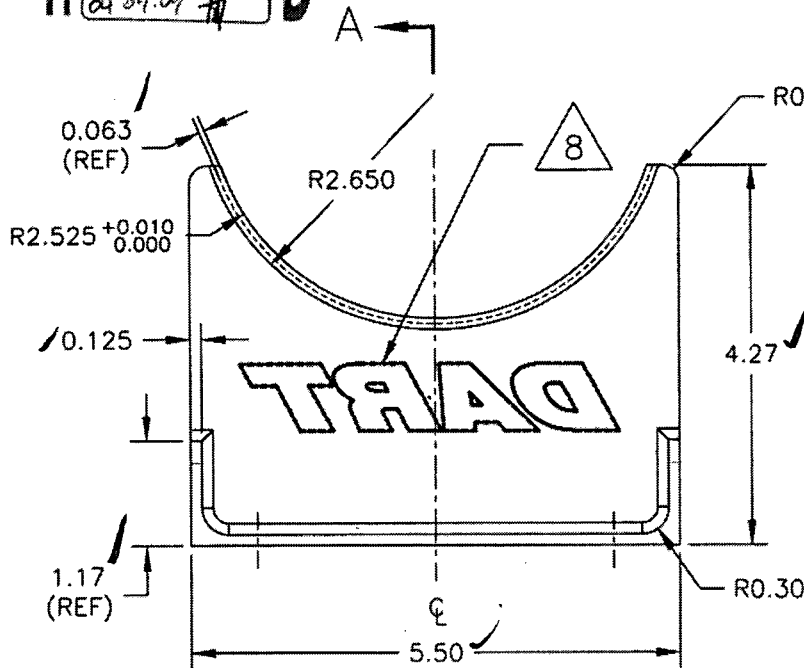
NO. 55233

REV 10-1-29

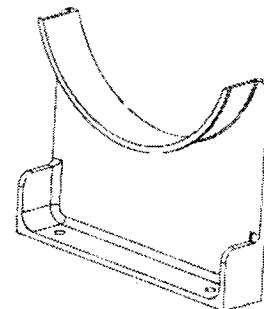


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3264	REV. A SHEET 1 OF 1
DATE 04.04.20	TITLE BRACKET		SCALE 1:2
A	04.04.20	NEW ISSUE	

RELEASED
04.04.20



SECTION A-A



D3264-1 BRACKET

D3264-1:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER
- 8) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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